



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-748-203
Job Sheet 196268



Part No: D350-748-203

Job Qty: 1 pcs

Part Name: AS350 / AS355 Stainless Steel Aft Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/19/19

Description: SIOP

Type: Stock

Note: D350-748-243 REV:A IPP REV:A 15.03.23 NEW ISSUE DD VERF;JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
110	Crosstubes - Bend - 1	1 pcs	7/19/19	7/19/19	0.50	2.44	Crosstubes - Bend	
127	QC 15	1 pcs	7/19/19	7/19/19	0.00	0.00	QC 15 - 12	
							QC 15 - 3	
							QC 15 - 47	
							QC 15 - 49	
							QC 15 - 58	
							QC 15 - 9	
							QC 15 - 68	
128	Crosstubes - 3 - B4B	1 pcs	7/19/19	7/19/19	0.00	1.98	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
130	Crosstubes - 4 - B4B	1 pcs	7/19/19	7/19/19	0.00	2.89	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
140	QC 5	1 pcs	7/19/19	7/19/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	

DAS
OCT 30 2019 68
9-89



Container No: S225519



Part: D350-748-203

Job No: 196268

Serial No/Batch: S225519

Revision: Rev A

Inspector:

Exp Date:

Instructions: TC STC SH06-27 Issue 2 FAA STC SR02359NY 11/03/04, EASA S

Dart Aerospace Ltd.
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CANADA
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6/11/2019

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DAS

40
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NOV 1 1 2019

2019-11-15

			QC 5 - 30			
			QC 5 - 40			
174	Outsource - 2 - NDT per QSI038	1 pcs	7/19/19		SKY002-VC	
176	Packaging 2-1 - Receive - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
178	QC 6	1 pcs	7/19/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
						DAS
						NOV 1 8 2019
180	Spray Paint - 2 - B4B	1 pcs	7/19/19	0.00 1.07	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
190	QC 14	1 pcs	7/19/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
						DAS
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				QC 14 - 43	
				QC 14 - 24	
200 Crosstubes - 5 - B4B	1 pcs	7/19/19	0.00 2.89	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	DAS 41 NOV 18 2019 9-89
210 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS NOV 20 2019 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
220 Packaging 1-1 - Pick Kit - B4B 1 pcs ✓		7/19/19	0.00 0.00	Packaging 1 - 1 - B4B ✓	Oscar
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

230 QC 4

1 pcs

7/19/19

0.00 0.00

QC 4 - 28

QC 4 - 58

QC 4 - 69

QC 4 - 9

QC 4 - 46

QC 4 - 68

QC 4 - 72

QC 4 - 74

DAS
78
9-89

NOV 21 2019

240 Packaging 3-1 - Stock - B4B

1 pcs

7/19/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

DAS
78
9-89

NOV 21 2019

245 DC - 1 - B4B

1 pcs

7/19/19

0.00 0.00

DC - 1 - B4B

DC - 2 - B4B

DAS
21
9-89

NOV 21 2019

250 QC 21 - FG

1 pcs

7/19/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - FG - 53

DAS
21
9-89

NOV 21 2019

Part Op 110 - CNC Alpha 160 Bender - Bend tube as per Dwg D350-748-243 using CNC bender program D350A and Folio
 Descriptions: FT *****UNDER BEND .225" PER SIDE*****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS*****

127 - QC15- Crosstube Dimensional Check ***MARK CUT LINES***

128 - Crosstubes - CUT TUBE AT HEIGHT ON FAI SHEET VERF HEIGHT 31.4375 BY QC 15 LEVEL INSPECTOR

130 - Crosstubes - 1- Drill Tube as per Dwg D350-748-243 Using DT8876 Drill Jigs, set-up drill table as per QSI 010. 2-
 Deburr 3- Engrave Part # and Batch # as per Dwg D350-748-243 4- Remove all marks from tube within limits of D350-
 748-243

140 - QC5- Inspect part completeness to step on W/O

174 - ISSUE P/O TO SKY SERVICE: 45097

176 - Receive & Inspect for Damage & Mat'l Certs

178 - QC6- All purchased or subcontracted products

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180 - Spray Paint / NDT Room ***VERIFY BY RD BATCH # TO MATCH W/O 196260 ***MASK
 SCRIBE B# & P# AND VERIFY*** 1. Apply Axalta 13205S Cleaner inside and outside crosstube per QSI 005 4.1.4
 BATCH: 5138949 2. Axalta 230S Metalok inside and outside crosstube per QSI 005 4.1.4 BATCH: M13802 3.
 Prime inside and outside crosstube per QSI 005 4.2 BATCH: 5187223 4. Paint outside of crosstube per QSI 005 4.2
 BATCH: 5231052
 190 - QC14- Inspect Spray Paint - Then, Wrap in plastic bag to protect from scratches ***VERIFY BY LG BATCH
 # TO MATCH W/O 196260
 200 - Crosstubes - INSTALL GROUND WIRE INSERT, THEN INSERT SCREW AND WASHER ***LIMIT AIR PRESSURE
 TO 50 PSI WHEN INSTALLING AETC-1032 INSERT AND ONLY EXPAND INSERT ONCE*** 1-Abraze mating surfaces
 of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2-Install supports
 with Proseal 890 per D350-748-243 and QSI 015 A/R Proseal 890 Batch: 5229895 EXP: 3/20 3-
 Install supports clamps Using Dt8876 as per Dwg D350-748-243, Torque to 60-80 IN-LBS. PROSEAL CURE TIME 72
 HOURS: Start: 19-11-17 Finish: 19-11-20
 210 - QC5- Inspect part completeness to step on W/O ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS
 CURED FOR 72HOURS AS PER DWG.*** **VERIFY BY _____ BATCH # TO MATCH W/O _____
 220 - Pick Kit
 230 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O _____
 240 - Identify and pack for shipping as per PPPD350-748-203 Location: _____ PPP Rev: _____
 245 - Document Control - Photocopy bluefile & type labels per PPPD350-748-203 CHG001
 250 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-748-243TRN	Crosstube Installation, High Aft	1 pcs (1 ea)	110-Crosstubes - Bend - 1	<u>5219741</u>
AETC-1032	Insert	1 Ea (1 ea)	200-Crosstubes - 5 - B4B	<u>FM137335</u>
D3502-1	Support	2 pcs (2 ea)	200-Crosstubes - 5 - B4B	<u>5188469</u>
D5123-7	Clamp Cushion	2 pcs (2 ea)	200-Crosstubes - 5 - B4B	<u>163264</u>
MS21920-20	Clamp	2 Ea (2 ea)	200-Crosstubes - 5 - B4B	<u>5103843</u>
NAS1149C0363R	Washer	1 Ea (1 ea)	200-Crosstubes - 5 - B4B	<u>M138326</u>
MS51958-83	Screw	1 pcs (1 ea)	200-Crosstubes - 5 - B4B	<u>FM134962</u>
AN4-41A	Bolt	8 Ea (8 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5058989</u> ✓
AN4-6A	Bolt	16 Ea (16 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5228778</u> ✓
AN5-32A	Bolt	4 Ea (4 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5119858</u> ✓
D3500-1	Saddle	4 pcs (4 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5133673</u> ✓
D3501-1	Bushing	16 pcs (16 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5217032</u> ✓
MS21042L4	Nut	24 Ea (24 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5225610616</u> ✓ S228617(x8)
MS21042L5	Nut	4 Ea (4 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5214642</u> ✓
NAS1149D0463J	Washer	32 Ea (32 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5228798-L</u> ✓
NAS1149D0563J	Washer	8 Ea (8 ea) ✓	220-Packaging 1-1 - Pick Kit - B4B	<u>5174288</u> ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Crosstubes - Bend - 1	D350-748-243TRN	1	0	0
200-Crosstubes - 5 - B4B	AETC-1032	1	19	0
	D3502-1	2	40	0
	D5123-7	2	265	0
	MS21920-20	2	105	0
	MS51958-83	1	46	0
	NAS1149C0363R	1	765	0
220-Packaging 1-1 - Pick Kit - B4B	AN4-41A	8	337	0
	AN4-6A	16	655	0
	AN5-32A	4	329	0
	D3500-1	4	59	0
	D3501-1	16	415	0
	MS21042L4	24	1,836	0
	MS21042L5	4	625	0
	NAS1149D0463J	32	2,902	0
	NAS1149D0563J	8	2,648	0

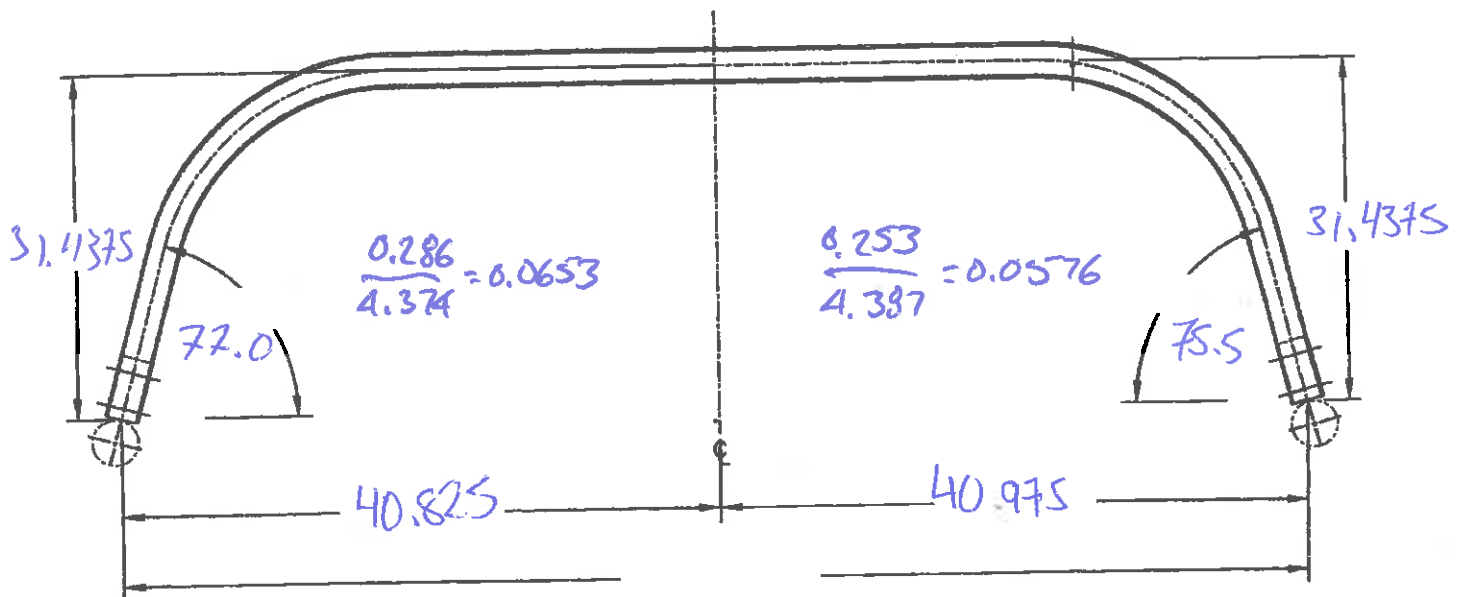
Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	196268
Description: Crosstube High Aft, SS (AS350/355)		Part Number:	D350-748-203
Inspection Dwg: D350-748-243 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	31.10	31.60
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06
Bending Passes	7	--
Crushing	--	8%
Twist	--	0.38



2.044
2.338

	Side A	Side B
Bending Passes	40	40
Crushing	6.5%	5.8%
Comments		
twist = 0.200"		

2.067
2.320

QC15 Inspection	DAS
Date	68 9-89 OCT 30 2019

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue	KJ	

Item	Qty	Part Number	Description
1	X	D350-748-243	CROSSTUBE ASSEMBLY (AS 3507355 HI AFT)
2	1	D8021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D5123-7	CLAMP CUSHION
5	1	AETC-1032	INSERT
6	2	MS21920-20	CLAMP
7	1	MS21920-21/22	(PER DART SPEC. M-MS21920-20/21/22)
8	1	NAS1148C0363R	WASHER (OR AN680C10)
9	1	NAS1835-3-8	SCREW (OR MS21950-83)
10	AIR	PROSEAL 880 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D8021-125
FINISHED LENGTH AFTER TURNING = 124.70±0.08 (AFTER BENDING/TRIMMING = 122.70 REF)
 - 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
 - 3) TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS 0.020 FROM NOMINAL
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 244 5.4 (VIBRATING STYLUS)
 - 7) WEIGHT: 29.85 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.280 HOLE.
 - 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLEND OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
 - 10) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
 - 11) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
 - 12) MAX AMPLITUDE OF RIBBLING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
 - 13) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).
- ASSEMBLY
- 14) TO INSTALL D3502-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.002" TO 0.005" THICK LAYER OF PROSEAL 880 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
 - 15) TORQUE CLAMPS 80 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 880 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196268M5
1906-11

DEF ATTACHED

RELEASED
2015 MAR 18

RELEASED

2015 MAR 18
REV 15/4/15
15/4/15

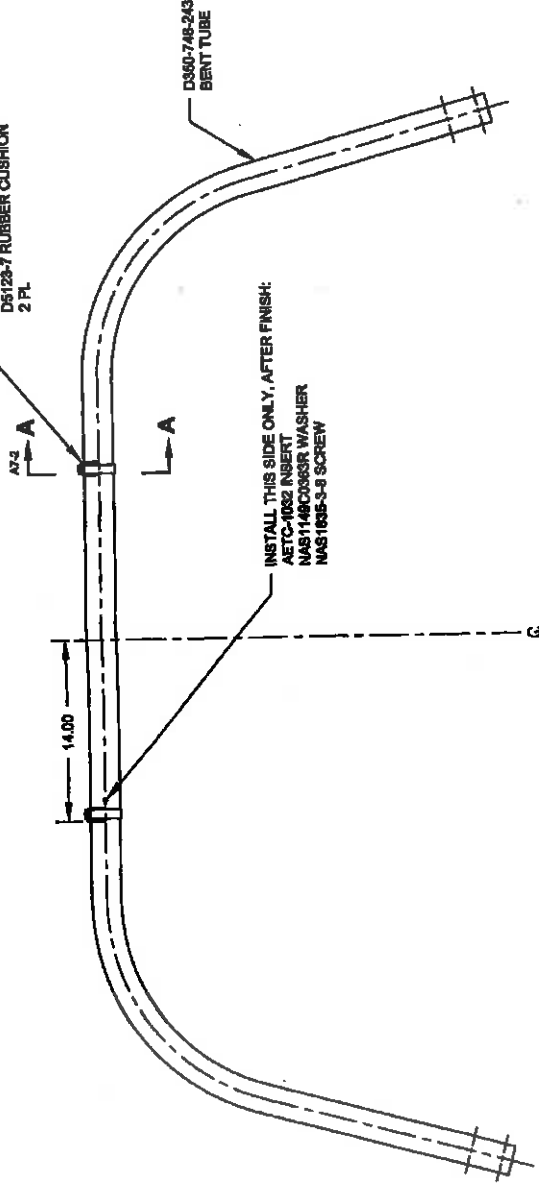
UNDER REVIEW

15/4/15
15/4/15

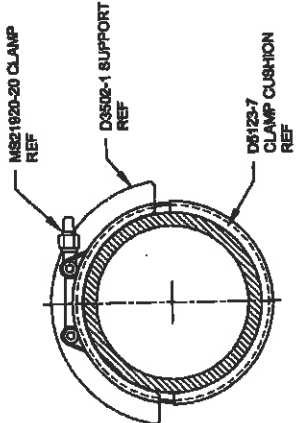
A	NEW ISSUE	DESCRIPTION	DATE
REV.	BY		
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D350-748-243	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DATE	15.01.21	CROSSTUBE (AS 3507355 HI AFT)	NTS

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14 15
D3502-1 SUPPORT
MS21920-20 CLAMP (OR -21-22)
D6123-7 RUBBER CUSHION
2 PL



**D350-748-243
ASSEMBLY DETAIL**



**SECTION AA
SCALE 8X**

DEO ATTACHED

RELEASED

2015 MAR 18 *q*

UNDER REVIEW

OK
11/12/14

DESIGN	00	DART AEROSPACE LTD
DRAWN	00	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P.	DRAWING NO.
MFG. APPR.	<i>q</i>	D350-748-243
APPROVED	<i>q</i>	REV. A
DE APPR.	<i>q</i>	SHEET 2 OF 4
DATE	15.01.21	TITLE
		CROSSTUBE (AS 350/365 HI AFT)
		SCALE
		NTS

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DRAWING NO. D350-748-243	TITLE CROSS TUBE	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D350-748-243-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 97	CHECKED AJS		MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>	
DATE 15.11.18	DATE 15.11.18		DATE 15.02.19	DATE FEB 19 2016		DATE 2016.02.19	

AMEND NOTE 2 (SHEET 1) AS FOLLOWS:

2) FINISH: PREPARE SURFACE PER DART QSI 005 4.1.4
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

OR

POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

RELEASED
2016-02-26
EN 16-534 *[Signature]*

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By		QC / QA Coordinator	
Root Cause		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Rework Scrap Use-as-is		Cross tube Small Fab Finishing Skid-tube Machining Large Fab		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality	